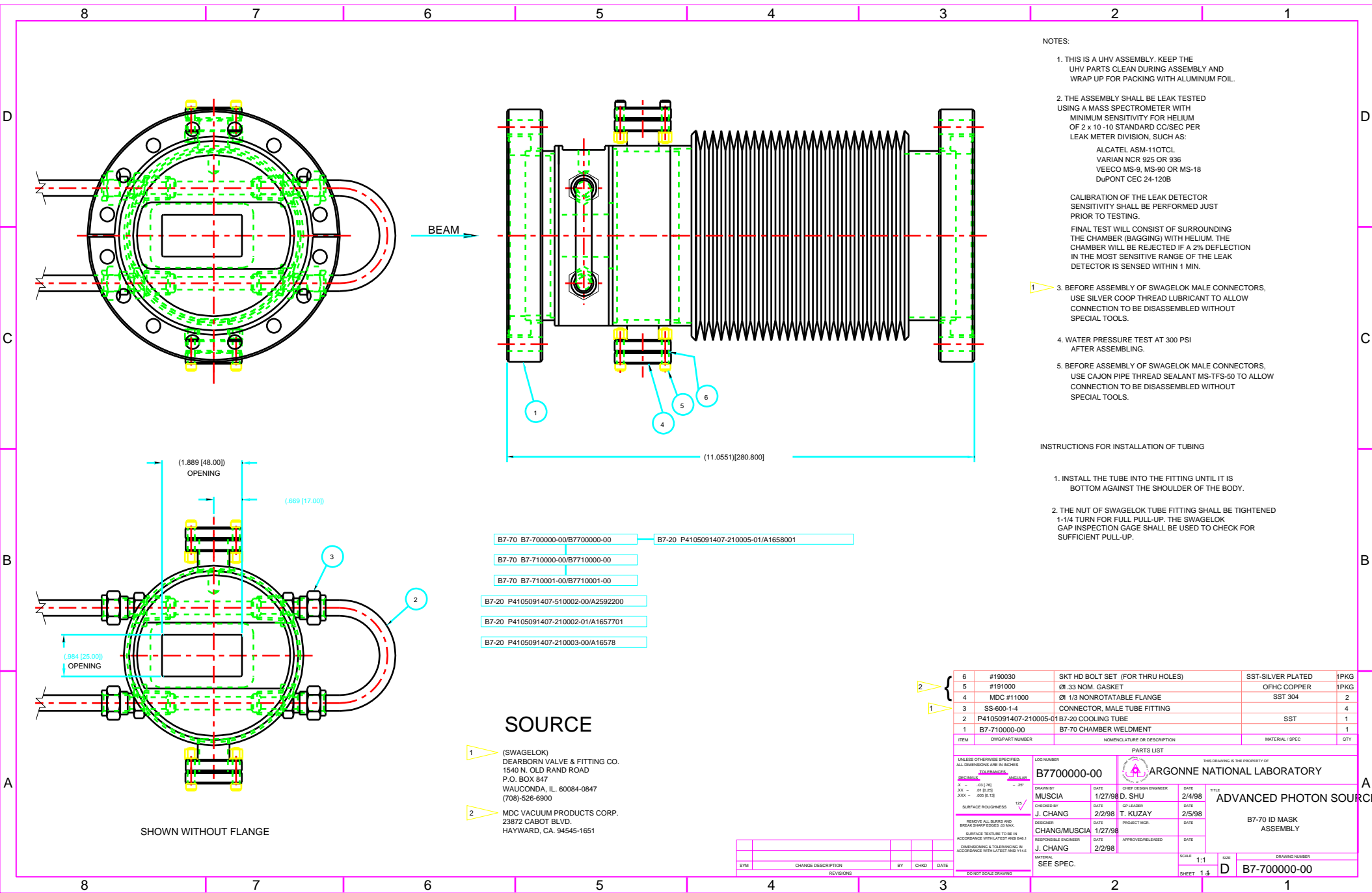


TRIM LINE



NOTES:

1. THIS IS A UHV ASSEMBLY. KEEP THE UHV PARTS CLEAN DURING ASSEMBLY AND WRAP UP FOR PACKING WITH ALUMINUM FOIL.
2. THE ASSEMBLY SHALL BE LEAK TESTED USING A MASS SPECTROMETER WITH MINIMUM SENSITIVITY FOR HELIUM OF 2×10^{-10} STANDARD CC/SEC PER LEAK MEASURE DIVISION. SUCH AS:
 - ALCATEL ASM-110TCL
 - VARIAN NCR 925 OR 936
 - VEECO MS-9, MS-90 OR MS-18
 - DUPONT CEC 24-120B
3. CALIBRATION OF THE LEAK DETECTOR SENSITIVITY SHALL BE PERFORMED JUST PRIOR TO TESTING.
4. FINAL TEST WILL CONSIST OF SURROUNDING THE CHAMBER (BAGGING) WITH HELIUM. THE CHAMBER WILL BE REJECTED IF A 2% DEFLECTION IN THE MOST SENSITIVE RANGE OF THE LEAK DETECTOR IS SENSED WITHIN 1 MIN.
5. BEFORE ASSEMBLY OF SWAGelok MALE CONNECTORS, USE SILVER COOP THREAD LUBRICANT TO ALLOW CONNECTION TO BE DISASSEMBLED WITHOUT SPECIAL TOOLS.
6. WATER PRESSURE TEST AT 300 PSI AFTER ASSEMBLING.
7. BEFORE ASSEMBLY OF SWAGelok MALE CONNECTORS, USE CAJON PIPE THREAD SEALANT MS-TFS-50 TO ALLOW CONNECTION TO BE DISASSEMBLED WITHOUT SPECIAL TOOLS.

INSTRUCTIONS FOR INSTALLATION OF TUBING

1. INSTALL THE TUBE INTO THE FITTING UNTIL IT IS BOTTOM AGAINST THE SHOULDER OF THE BODY.
2. THE NUT OF SWAGELOK TUBE FITTING SHALL BE TIGHTENED 1-1/4 TURN FOR FULL PULL-UP. THE SWAGELOK GAP INSPECTION GAGE SHALL BE USED TO CHECK FOR SUFFICIENT PULL-UP.

SOURCE

- 1 (SWAGELOK)
DEARBORN VALVE & FITTING CO.
1540 N. OLD RAND ROAD
P.O. BOX 847
WAUCONDA, IL. 60084-0847
(708)-526-6900
- 2 MDC VACUUM PRODUCTS CORP.
23872 CABOT BLVD.
HAYWARD, CA. 94545-1651

<div><div>2</div><div>}</div><div>1</div><div>}</div></div>	6	#1910030	SKT HD BOLT SET (FOR THRU HOLES)	SST-SILVER PLATED	1 PKG
		#191001	Ø3.33 NOM. GASKET	OFHC COPPER	1 PKG
		MDC #11000	Ø1 1/8 NONROTATABLE FLANGE	SST 304	2
		SS-601-1-4	CONNECTOR, MALE TUBE FITTING		4
		P410509147-210005-0	B7-20 COOLING TUBE	SST	1
	B7-101000-00	B7-70 CHAMBER WELDMENT		1	
ITEM		DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION		QTY
PARTS LIST					
UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES DECIMALS FRACTIONS ANGULAR		LOG NUMBER B7700000-00		THIS DRAWING IS THE PROPERTY OF <div>ARGONNE NATIONAL LABORATORY</div>	
SURFACE ROUGHNESS 1/8"		DRAWN BY MUSCIA	DATE 1/27/98	CHIEF DESIGN ENGINEER D. SHU	DATE 2/4/98
REMOVE ALL BURRS AND BREAK SHARP EDGES TO MAX. SURFACE TEXTURE TO BE IN ACCORDANCE WITH TITL-1 AND B4-1 DIMENSIONING & TOLERANCING IN ACCORDANCE WITH TITL-1 AND T14.5		CHECKED BY J. CHANG	DATE 2/2/98	GP LEADER T. KUZAY	DATE 2/4/98
CRYD DATE		DESIGNED CHANG/MUSCIA	DATE 1/27/98	PROJECT MGR. DATE	B7-70 ID MASK ASSEMBLY
DO NOT SCALE DRAWING		RESPONSIBLE ENGINEER J. CHANG	DATE 2/2/98	APPROVED/RELEASED DATE	DRAWING NUMBER B7-700000-00